

Work Order ID 85220

85220

Page 1

June-04-12 3:50:20 PM

Item ID: DSI 9053-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Basket Hinge Change

Start Date: 04/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/06/04

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| DSI 9053 | Rev N/A | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* | DOCUMENT CONTROL | | | | | | | | |
| DC | Memo | 0.00 | | | | | | | |
| Document Control | Photocopy bluefile and create labels as per PPP DSI 9053-011 CHG001 | | | | | | | | |
| 110 | Pick Kit | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 120 | QC4- 100% Inspect kits for completeness | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

8/12/06/07 JB

ML5 12-6-26 (2)

2 12/06/26 JB

8/12/06/07

(42)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

June-04-12 3:50:20 PM

85220

Page 2

Accept

N900040100

Setup Start *NS1*

Item Name: Basket Hinge Change

Stop *NS2*

Start Date: 04/06/2012 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 18/06/2012 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

0.00

130

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP Dsi9053-011 Location: 2A PPP Rev: 11

011Location: PPP Rev:

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

June-04-12 3:50:24 PM

Page 1

Work Order ID: 85220

85220

Parent Item: DSI 9053-011

DSI 9053-011

Parent Item Name: Basket Hinge Change

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A02.05.15New IssueNG

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MS21042L4 | | Purchased | No | | | 110 | Each | 3,904.000 | 2 | 4 | | | |

MS21042L4

Nut

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST300 | 3904 | |
| 119075 | 116 | |
| 121011 | 531 | |
| 121444 | 2957 | |
| 121652 | 300 | |

AN3-12A

Bolt

| | | | | | | | | |
|-----------|----|--|-----|------|---------|---|---|--|
| Purchased | No | | 120 | Each | 69.0000 | 4 | 8 | |
|-----------|----|--|-----|------|---------|---|---|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST351 | 69 | |
| 114536 | 1 | |
| 119641 | 18 | |
| 121825 | 50 | |

AN3-14A

Bolt

| | | | | | | | | |
|-----------|----|--|-----|------|---------|---|----|--|
| Purchased | No | | 120 | Each | 81.0000 | 6 | 12 | |
|-----------|----|--|-----|------|---------|---|----|--|

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST352 | 81 | |
| 121415 | 6 | |
| 121444 | 25 | |
| 121708 | 50 | |

**

**

**

JB

JB

JB

12/06/26

11x121444

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

June-04-12 3:50:24 PM

Work Order ID: 85220

85220

Parent Item: DSI 9053-011

DSI 9053-011

Parent Item Name: Basket Hinge Change

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 2.00

Required Qty: 2.00

AN4-6A Purchased No

AN4-6A

Bolt

120 Each

1,513.000

2

4

**

Location

Loc Qty

Loc Code

355

221

121631

221

ST356

1292

119017

792

121243

500

119017

AN960JD10 NAS1149D0363J Purchased No

AN960JD10

Washer

120 Each

0.0000

40

80

**

121524

AN960JD416 NAS1149D0463J Purchased No

AN960JD416

Washer

120 Each

30.0000

8

16

**

121912

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

D2232-1 Manufactured No

D2232-1

Basket Hinge

120 Each

12.0000

2

4

**

78992

12/06/26

Location

Loc Qty

Loc Code

WA

12

78992

10

79472

2

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

June-04-12 3:50:25 PM

Work Order ID: 85220

85220

Parent Item: DSI 9053-011

DSI 9053-011

Parent Item Name: Basket Hinge Change

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 2.00

Required Qty: 2.00

D2232-3

Manufactured No

120

Each

11.0000

2

4

**

D2232-3

Basket Hinge

Location

Loc Qty

Loc Code

WA

9

82304

9

WA005

2

75581

2

82304

MS2104213

Purchased

No

120

Each

2,157.000

10

20

**

MS210421 3

Nut

Location

Loc Qty

Loc Code

ST300

2157

117885

32

119017

952

119075

138

121349

215

121444

820

121444

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|---------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval. QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries

SUPERCEDED BY

D205-541 REV E

SUPERCEDED BY

D350-607 REV. F

DART

| | | | |
|---------------------|-----------------------|--|------------------------|
| DESIGN <i>UP</i> | DRAWN BY <i>UP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>#</i> | APPROVED <i>#</i> | DRAWING NO. DSI 9053 | REV. B SHEET 1 OF 2 |
| DATE 01.04.16 | | TITLE BASKET HINGE CHANGE | SCALE NTS |
| A | 96.11.06 | NEW ISSUE | |
| B | 01.04.16 | REDRAWN | |

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION DRAWING D205-541 REV. D
(REF. CANADIAN STC: SH96-120, FAA STC: SR00696NY)
AND INSTALLATION DRAWING D350-607 REV. E
(REF. CANADIAN STC: SH94-14, FAA STC: SR00213NY)

IF THE D2569 HINGE IS BEING REPLACED, THE PARTS LIST OF D205-541 REV. D (D205-541-011 CHG 003) / D350-607 REV. E (D350-607-041/-042 CHG 004) SHOULD BE AMENDED AS FOLLOWS:

REPLACE:

| Qty | Part Number | Description |
|-----|-------------|-------------|
| 1 | D2569 | HINGE |
| 36 | AD64ABSLF | RIVET |

WITH:

| Qty | Part Number | Description |
|-----|--------------|--------------------|
| X | DSI 9053-011 | HINGE CHANGE KIT |
| 2 | D2232-1 | HINGE PLATE |
| 2 | D2232-3 | HINGE PLATE |
| 4 | AN3-12A | BOLT |
| 6 | AN3-14A | BOLT |
| 2 | AN4-6A | BOLT |
| 40 | AN960JD10 | WASHER* |
| 8 | AN960JD416 | WASHER* |
| 10 | MS21042L3 | NUT (OR MS21042-3) |
| 2 | MS21042L4 | NUT (OR MS21042-4) |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85220 JCS
(2/06/04)

* NOTE: IT IS ALSO ACCEPTABLE TO REPLACE THE WASHERS THAT ARE USED AS SPACERS WITH A SINGLE ALUMINUM SPACER OF APPROPRIATE LENGTH (SEE PAGE 2).

REPLACE D2569 HINGE AS FOLLOWS:

- 1) REMOVE EXISTING HINGE BY DRILLING OUT AD64ABSLF RIVETS. PLUG HOLES WITH RIVETS IF DESIRED.
- 2) DRILL HOLES IN D2232-1/-3 HINGE PLATES AS SHOWN ON PAGE 2.
- 3) LOCATE D2232-1 HINGE PLATE ON D2512 BASKET LID ASSEMBLY. REMOVE MESH AS REQUIRED SO THAT D2232-1 HINGE PLATE SITS FLUSH ON D2512 BASKET LID ASSEMBLY. TRANSFER DRILL Ø0.191 HOLES. INSTALL D2232-1 HINGE PLATE WITH HARDWARE AS SHOWN ON PAGE 2. REPEAT AT OTHER END OF BASKET.
- 4) LOCATE POSITION OF D2232-3 HINGE PLATE FROM D2232-1 HINGE PLATE BY ENSURING Ø0.257 HOLE IS ALIGNED. REMOVE MESH AS REQUIRED TO ENSURE THAT D2232-3 HINGE PLATE AND ATTACHMENT HARDWARE SITS FLUSH AGAINST D2206/D2221 BASKET BASE ASSEMBLY. TRANSFER DRILL Ø0.191 HOLES. INSTALL D2232-3 HINGE PLATE WITH HARDWARE AS SHOWN ON PAGE 2. REPEAT AT OTHER END OF BASKET.
- 5) TOUCH UP PAINT AS REQUIRED.

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

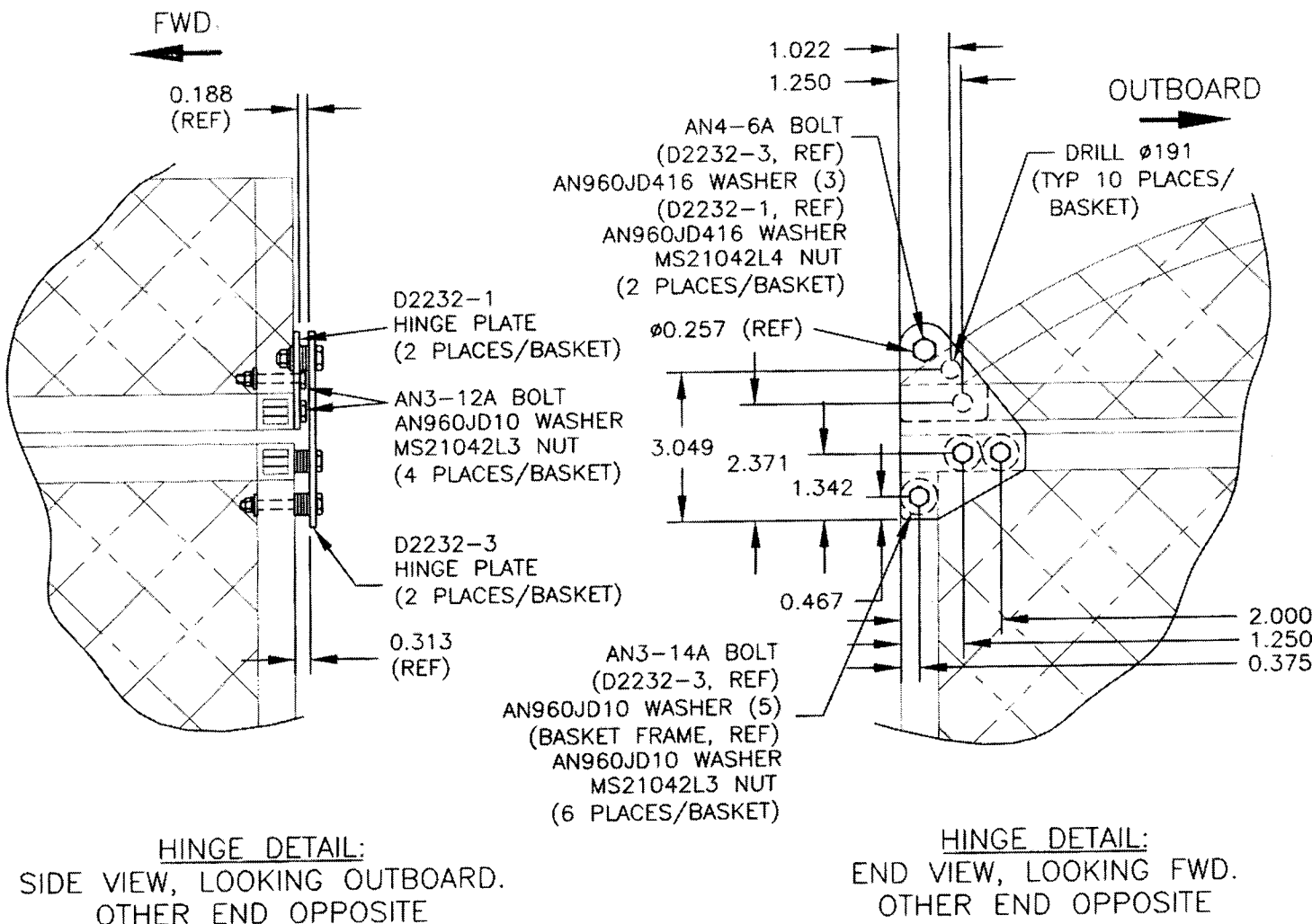
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

SUPERCEDED BY
0205-541 Rev. E
SUPERCEDED BY
D350 607 Rev. F

| | | | | |
|---------|---------------------|-------------|----------|---|
| DESIGN | 01 | DRAWN BY | 01 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | 01 | APPROVED | 01 | REV. B |
| DATE | 01.04.16 | DRAWING NO. | DSI 9053 | SHEET 2 OF 2 |
| TITLE | BASKET HINGE CHANGE | SCALE | NTS | |

25120



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>UP</i> | DRAWN BY <i>UP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. DSI 9053 | REV. B SHEET 1 OF 2 |
| DATE 01.04.16 | | TITLE BASKET HINGE CHANGE SCALE NTS | |
| A | 96.11.06 | NEW ISSUE | |
| B | 01.04.16 | REDRAWN | |

DART SERVICE INSTRUCTION

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(REF. CANADIAN STC: SH96-120, FAA STC: SR00696NY)
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(REF. CANADIAN STC: SH94-14, FAA STC: SR00213NY)

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|-----|--------------|--------------------|
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| 4 | AN3-12A | BOLT |
| 6 | AN3-14A | BOLT |
| 2 | AN4-6A | BOLT |
| 40 | AN960JD10 | WASHER* |
| 8 | AN960JD416 | WASHER* |
| 10 | MS21042L3 | NUT (OR MS21042-3) |
| 2 | MS21042L4 | NUT (OR MS21042-4) |

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REPLACE D2569 HINGE AS FOLLOWS:

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- 3) LOCATE D2232-1 HINGE PLATE ON D2512 BASKET LID ASSEMBLY. REMOVE MESH AS REQUIRED SO THAT D2232-1 HINGE PLATE SITS FLUSH ON D2512 BASKET LID ASSEMBLY. TRANSFER DRILL Ø0.191 HOLES. INSTALL D2232-1 HINGE PLATE WITH HARDWARE AS SHOWN ON PAGE 2. REPEAT AT OTHER END OF BASKET.
- 4) LOCATE POSITION OF D2232-3 HINGE PLATE FROM D2232-1 HINGE PLATE BY ENSURING Ø0.257 HOLE IS ALIGNED. REMOVE MESH AS REQUIRED TO ENSURE THAT D2232-3 HINGE PLATE AND ATTACHMENT HARDWARE SITS FLUSH AGAINST D2206/D2221 BASKET BASE ASSEMBLY. TRANSFER DRILL Ø0.191 HOLES. INSTALL D2232-3 HINGE PLATE WITH HARDWARE AS SHOWN ON PAGE 2. REPEAT AT OTHER END OF BASKET.
- 5) TOUCH UP PAINT AS REQUIRED.

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DART

| | | | | | |
|---------|----------|----------|----|--|--------------|
| DESIGN | CP | DRAWN BY | CP | DART AEROSPACE LTD. HAMKESBURY, ONTARIO, CANADA | |
| CHECKED | ✓ | APPROVED | ✓ | DRAWING NO. | REV. B |
| DATE | 01.04.16 | | | DSI 9053 | SHEET 2 OF 2 |
| | | | | TITLE | SCALE |
| | | | | BASKET HINGE CHANGE | NTS |

